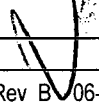



Date: Friday, 09/03/2007 10:24:25 AM
 User: Linda Lacelle

Process Sheet

| | | | |
|-----------------------|--|------------------|---------------------|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : AFT TUBE ASSEMBLY |
| Job Number | : 31154 | | |
| Estimate Number | : 10699 | | |
| P.O. Number | : N/A | Part Number | : D3391025 |
| This Issue | : 09/03/2007 S.O. No. : N/A | Drawing Number | : D3391 REV E |
| Prsht Rev. | : NC | Project Number | : N/A |
| First Issue | : N/A Type : LANDING GEAR | Drawing Revision | : E |
| Previous Run | : 31153 | Material | : N/A |
| Written By | :  | Due Date | : 30/03/2007 |
| Checked & Approved By | :  | Qty: | 1 Um: Each |
| Comment | : Est Rev B 06-02-07 ECN773 dwg rev. D EC Est Rev: C 06-03-28 Update Manufacturing Instructions JLM | | |

Additional Product

Job Number:



| | | |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

| | | |
|-----|----------|--------------------|
| 1.0 | D6014090 | ALUMINUM EXTRUSION |
|-----|----------|--------------------|



Comment: Qty.: 1.0000 f(s)/Unit Total: 1.0000 f(s)

ALUMINUM EXTRUSION

Pick:

Qty Part Number Description Batch

1 D6014-090 Extrusion B26546

Identify as D3391-3

SF 07/03/09

| | | |
|-----|------------|----------------------------|
| 2.0 | MORI SEIKI | MORI SEIKI CNC LATHE LARGE |
|-----|------------|----------------------------|



Comment: MORI SEIKI CNC LATHE LARGE

Turn as per Folio FA599

Rev: M & Dwg D3391 Rev: E

SF 07/03/09

| | | |
|-----|-----|--|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

BC 07.03.10 (6)

| | | |
|-----|-------|--------------------------------|
| 4.0 | HAAS1 | HAAS CNC VERTICAL MACHINING #1 |
|-----|-------|--------------------------------|



Comment: HAAS

1-Machine as per Folio FA 599 Rev: AA & Dwg D3391 Rev: E

2-Drill (PILOT HOLE) aft cap holes per Dwg D3391 using DT8803

3-Deburr

SF 07/03/09

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Date: Friday, 09/03/2007 10:24:25 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT TUBE ASSEMBLY

Job Number: 31154

Part Number: D3391025

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

En 07/03/12

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.L 07/03/12

7.0

BENDING

BENDING MACHINE



Comment: NC Bender

Form as per Dwg D3391 Using Bend Prog 3391025

DP 7-3-14

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

BE 07-3-14

9.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open Aft cap pilot hole to .208" as per Dwg D3391

Pm 07-03-14 (1)

2-Drill Tube as per D3391 using DT8809 (HOLES MARKED "A" ONLY)

Pm 07-03-14 (1)

3-Drill and c' sink wearshoe holes as per Dwg D3391 Using DT8878(Mid Tube) & DT8217 Wearplate Jig

Pm 07-03-14 (1)

4-C'sink holes for float bag (4 holes per side) as per Dwg D3391

Pm 07-03-14 (1)

5-Deburr

Pm 07-03-14 (1)

Tools: rill

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/03/14

11.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

HS / M-H

07-03-20 (1)

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Date: Friday, 09/03/2007 10:24:25 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT TUBE ASSEMBLY

Job Number: 31154

Part Number: D3391025

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

POWDER COATING

POWDER COATING



m/103706

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

FL

07/03/22

(1)

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Q.M

07/03/22

(1)

14.0

NAS1330C3KB166

INSERT



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

INSERT

Pick:

Qty

Part Number

Description

Batch

8

NAS1330C3KB166

Insert

M101396

Q.M 07/03/22

(1)

15.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Install Inserts as per dwg

Q.M

07/03/22

(1)

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

M 07/03/22

(1)

17.0

AESS10KB366

INSERT



Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)

Insert

Pick:

Qty

Part Number

Description

Batch

14

AESS10KB366

Insert

M 103758

18.0

AESS10KB266

INSERT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

INSERT

Pick:

Qty

Part Number

Description

Batch

2

AESS10KB266

Insert

or NAS1330C3KB266

M 17905

Q.M 07/03/22

(1)

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Date: Friday, 09/03/2007 10:24:26 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT TUBE ASSEMBLY

Job Number: 31154

Part Number: D3391025

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

AESS10KB316

INSERT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

INSERT

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------------|-------------|--------|
| 2 | AESS10KB316 | Insert | M17905 |
| | or NAS1330C3KB316 | | |

20.0

D2646

Aft Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Aft Cap

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|--------|
| 1 | D2646 | Aft Cap | B30119 |

21.0

AN3C4A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|---------|
| 2 | AN3C4A | Bolt | M103691 |

22.0

AN960C10L

washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Inventory

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|---------|
| 2 | AN960C10L | Washer | M103691 |

23.0

NAS1515H3L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

WASHER

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|---------|
| 2 | NAS1515H3L | Washer | M103691 |

Ed 07/03/27 ①

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/03/08
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Date: Friday, 09/03/2007 10:24:26 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT TUBE ASSEMBLY

Job Number: 31154

Part Number: D3391025

Job Number:



Seq. #:

Machine Or Operation:

Description :

24.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Install inserts as per Dwg D3391

2-Install Aft Cap as per Dwg D3391

A/ R Sikaflex-241/-291 *m103497*

Sikaflex expiry date: *07/10.*

FL 07/03/27 ①

25.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

2070328 ①

26.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

PPP B30919 07/2/28 ①

27.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Final 07/03/28 ①

Job Completion



u 07-03-28

Dart Aero

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

| | | | |
|--|--|---------------------|---------|
| DART AEROSPACE LTD | | Work Order: | 31/54 |
| Description: Float Skidtube (412) | | Part Number: | D3391-3 |
| Inspection Dwg: D3391 Rev: E | | Page 1 of 1 | |

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**

 ☐ **Prototype**

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|---------------|------------------|--------|--------|----------------------|----------|
| 14.000 | +/-0.010 | 14.000 | ✓ | | | |
| 3.500 | +/-0.010 | | | | | |
| 88.93 | +/-0.030 | 88.93 | ✓ | | | |
| 44.995 | +/-0.030 | 45.000 | ✓ | | | |
| 3.200 | +/-0.010 | 3.208 | ✓ | | | |
| 1.526 | +0.000/-0.030 | 1.528 | ✓ | | | |
| 0.200 | +/-0.010 | 0.203 | ✓ | | | |
| 7.500 | +/-0.010 | 7.498 | ✓ | | | |
| 27.750 | +/-0.010 | 27.750 | ✓ | | Tape measure | |
| 31.750 | +/-0.010 | 31.750 | ✓ | | Tape measure | |
| 35.250 | +/-0.010 | 35.250 | ✓ | | Tape measure | |
| 0.400 | +/-0.010 | | | | | |
| Ø0.208 | +0.005/-0.001 | | | | | |
| 3.300 | +/-0.010 | 3.297 | ✓ | | | |
| 0.200 | +/-0.010 | 0.203 | | | | |
| 3.520 | +/-0.010 | 3.529 | ✓ | | | |
| 0.687 | +0.010/-0.000 | 0.688 | | | | |
| R0.062 | +/-0.010 | 0.062 | ✓ | | | |
| Ø0.484 | +0.005/-0.001 | 0.484 | ✓ | | | |
| | | | | | | |
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| | | | |
|--|-------------------------|----------------------------|-----|
| Measured by: S.B. / [Signature] | Audited by: J.L. | Prototype Approval: | N/A |
| Date: 07/03/09 | Date: 07/03/13 | Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|------------------------------|------------|-------------|
| A | 06.04.24 | New Issue P/O D3391-025 | KJ/JLM | |
| B | 06.06.19 | Dwg revision update | KJ/JLM | [Signature] |

